

# Work Order ID 81941

**\*81941\***

Page 1

March-21-12 9:52:17 AM

Item ID: D4545-047

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Retainer, Inner, LH (Top)

Start Date: 21/03/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/21 Tooling:

Date:

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4545	B

100	Pick Kit	0.00
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**\*100\***

Packaging Memo 0.00

Packaging

110		0.00
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**\*110\***

Small Fab Memo 0.00

Small Fab

1- ASSEMBLE AND BEND TABS AS PER DWG

2- TRANSFER DRILL HOLES AS PER DWG.

3- DISASSEMBLE AND DEBURR

4- DIMPLE HOLES AS PER DWG

SD 12/03/21

(2) FF 12-03-22

W/O: 81941		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr.	Approval QC Inspector

Part No: D 4545-047 PAR #: \_\_\_\_\_ Fault Category: Small Feb NCR: Yes No DQA: ✓ Date: 12/03/29  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ✓ Date: 12/3/29

NCR: 121298		WORK ORDER NON-CONFORMANCE (NCR) 57-95						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/03/22	110	2 pieces D4542-7 were scrap diff on the opposite side  RC process	<u>[Signature]</u> Q4542	Scrap & destroy <del>scrap</del>	<u>S</u> 12/03/21	<u>S</u> 12/03/26	<u>[Signature]</u> Q4542	<u>S</u> 12/03/26

NOTE: Date & initial all entries

# Work Order ID 81941

\*81941\*

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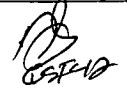
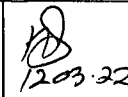
March-21-12 9:52:17 AM

Item ID: D4545-047 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Retainer, Inner, LH (Top)  
 Start Date: 21/03/2012 Start Qty: 2.00 \*2\* Cust Item ID:  
 Required Date: 04/04/2012 Req'd Qty: 2.00 \*2\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
*120*									
QC	Memo	0.00							
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00							
*130*									
HandFinish	Memo	0.00							
Hand Finishing									
140	QC7-Inspect Chemical Conversion Coat	0.00							
*140*									
QC	Memo	0.00							
Quality Control									

② 1203.22  
 2 123.22  
 2x4 m 12/03/22  
 PTO

W/O: 81941		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12-03-22	145 + 146	Install nutplates before paint		12-03-22	2		

Part No: P4545-017 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 81941

**\*81941\***

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March-21-12 9:52:17 AM

Item ID: D4545-047 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Retainer, Inner, LH (Top)  
 Start Date: 21/03/2012 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 04/04/2012 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 <b>*150*</b> Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3  Memo START TIME: <u>10h35</u> OVEN TEMPERATURE: <u>320°F</u> FINISH TIME: <u>11h05</u>	0.00  0.00				2	2	(2P)	12/03/23.
160 <b>*160*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				2	12	3	23
170 <b>*170*</b> Small Fab Small Fab	INSTALL NUT PLATES AS PER DWG  Memo	0.00  0.00				(2)	12	03	23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Work Order ID 81941

March-21-12 9:52:17 AM

**\*81941\***

Page 4

Item ID: D4545-047 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Retainer, Inner, LH (Top)  
 Start Date: 21/03/2012 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 04/04/2012 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00							
<del>*180*</del> QC Quality Control	Memo	0.00				12/03/23			SPR
190	Identify as per dwg & Stock Location: <u>442</u>	0.00							
<del>*190*</del> Packaging Packaging	Memo	0.00				12/3/23			SPR
200	QC21- Final Inspection - Work Order Release	0.00							
<del>*200*</del> QC Quality Control	Memo	0.00				ML5 12/03/26			ML5 12-03-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

March-21-12 9:52:23 AM

Page 1

Work Order ID: 81941

**\*81941\***

Parent Item: D4545-047

**\*D4545-047\***

Parent Item Name: Retainer, Inner, LH (Top)

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.01.13 new issue DD verf:JLM  
12.02.27 AS PER DWG REV.B DD VERF:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4541-7		Manufactured	No			100	Each	3.0000	1	2			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

**\*D4541-7\***

Bracket

\*\* (2) FF 12-03-23

Location

Loc Qty

Loc Code

FG

3

B 81264

(2)

78768

3

D4542-7		Manufactured	No			100	Each	3.0000	1	2			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

**\*D4542-7\***

Retainer, Inner

\*\* (2) FF 12-03-23

Location

Loc Qty

Loc Code

FG

3

B 80269

(2)

78774

3

MS20426AD3-4		Purchased	No			170	Each	3,914.000	16	32			
--------------	--	-----------	----	--	--	-----	------	-----------	----	----	--	--	--

**\*MS20426AD3-4\***

RIVET

\*\* (2) FF 12-03-23

Location

Loc Qty

Loc Code

ST316

3914

104374

1006

110398

2908

32

MS21059L3K		Purchased	No			170	Each	0.0000	8	16			
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**\*MS21059L3K\***

Nutplate

\*\* (2) FF 12-03-23

M 121114

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY -041	QTY -042	QTY -043	QTY -044	QTY -045	QTY -046	QTY -047	QTY -048	PART NUMBER	DESCRIPTION
	X								D4545-041	RETAINER, LH INNER (LOWER)
		X							D4545-042	RETAINER, RH INNER (LOWER)
			X						D4545-043	RETAINER, LH INNER (SIDE)
				X					D4545-044	RETAINER, RH INNER (SIDE)
					X				D4545-045	RETAINER, LH INNER (TOP CORNER)
						X			D4545-046	RETAINER, RH INNER (TOP CORNER)
							X		D4545-047	RETAINER, LH INNER (TOP)
								X	D4545-048	RETAINER, RH INNER (TOP)
1	1								D4541-1	BRACKET
2		1							D4541-2	BRACKET
3			1	1					D4541-3	BRACKET
4					1	1			D4541-5	BRACKET
5							1	1	D4541-7	BRACKET
6	1								D4542-1	RETAINER
7		1							D4542-2	RETAINER
8			1	1					D4542-3	RETAINER
9					1	1			D4542-5	RETAINER
10							1	1	D4542-7	RETAINER
11	40	38	28	28	12	12	16	16	MS20426AD3-4	RIVET
12	19	18	14	14	6	6	8	8	MS21059L3K	NUTPLATE
13	1	1							MS21061L3K	NUTPLATE

~~8050~~ M.C.J  
81941 12/03/21

RELEASED  
2012-02-16

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: PRIOR TO ASSEMBLY, POWDER COAT D4541-X & D4542-X WITH BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: -041/-042 = 0.38 lbs, -043/-044 = 0.27 lbs,  
-045/-046 = 0.11 lbs, -047/-048 = 0.15 lbs
- 8) BEND INDIVIDUAL TABS ON D4541-X BRACKETS TO CORRESPONDING "A#" (A1, A2, ETC.,) VALUE

B	ADD FINISH (ZN A8-1)	CP	12.02.01
A	NEW ISSUE	CP	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED	A.S.		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.02.01		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4545	REV. B SHEET 1 OF 9
TITLE RETAINER, INNER	SCALE NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

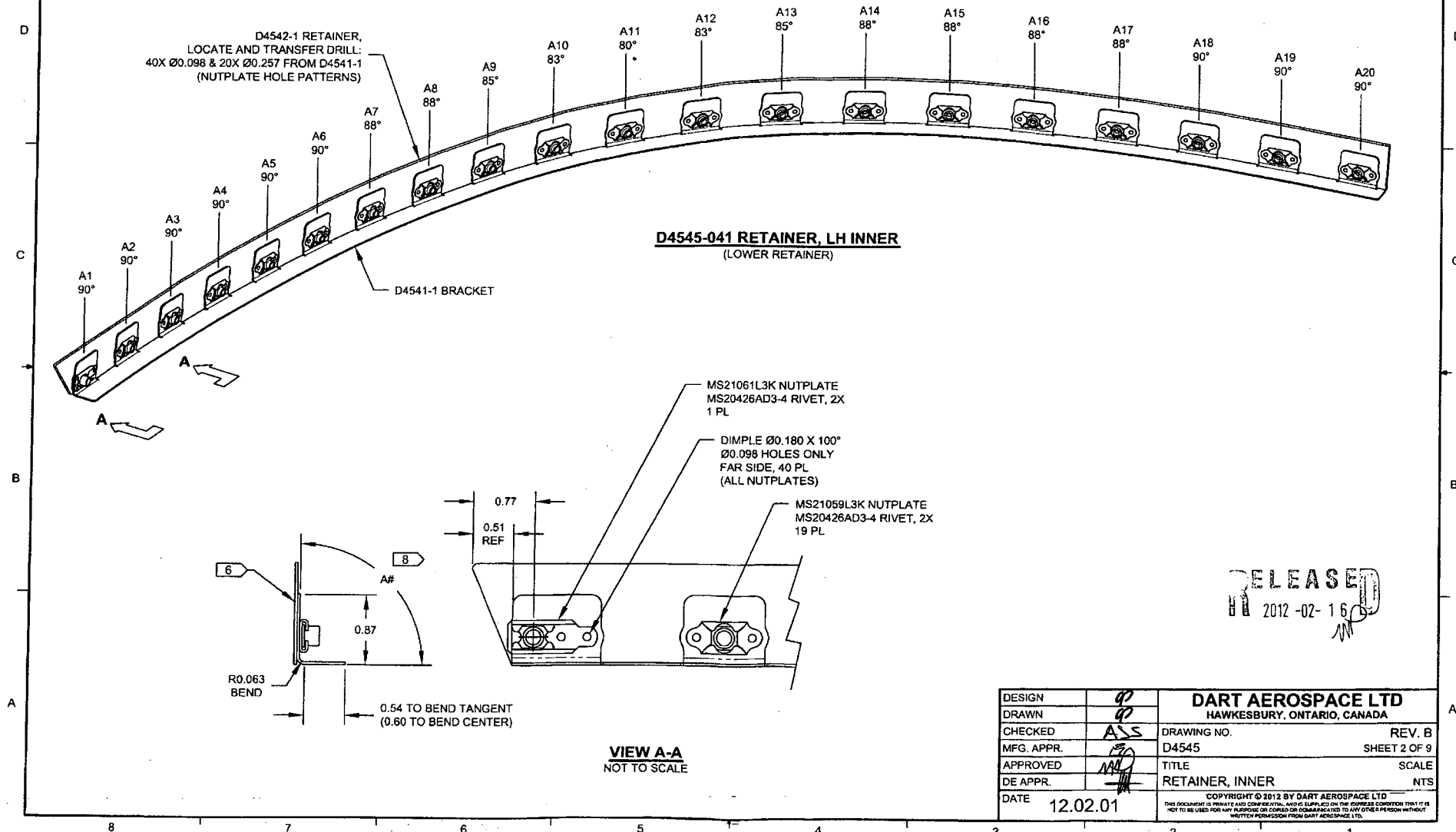
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

81941

81941



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

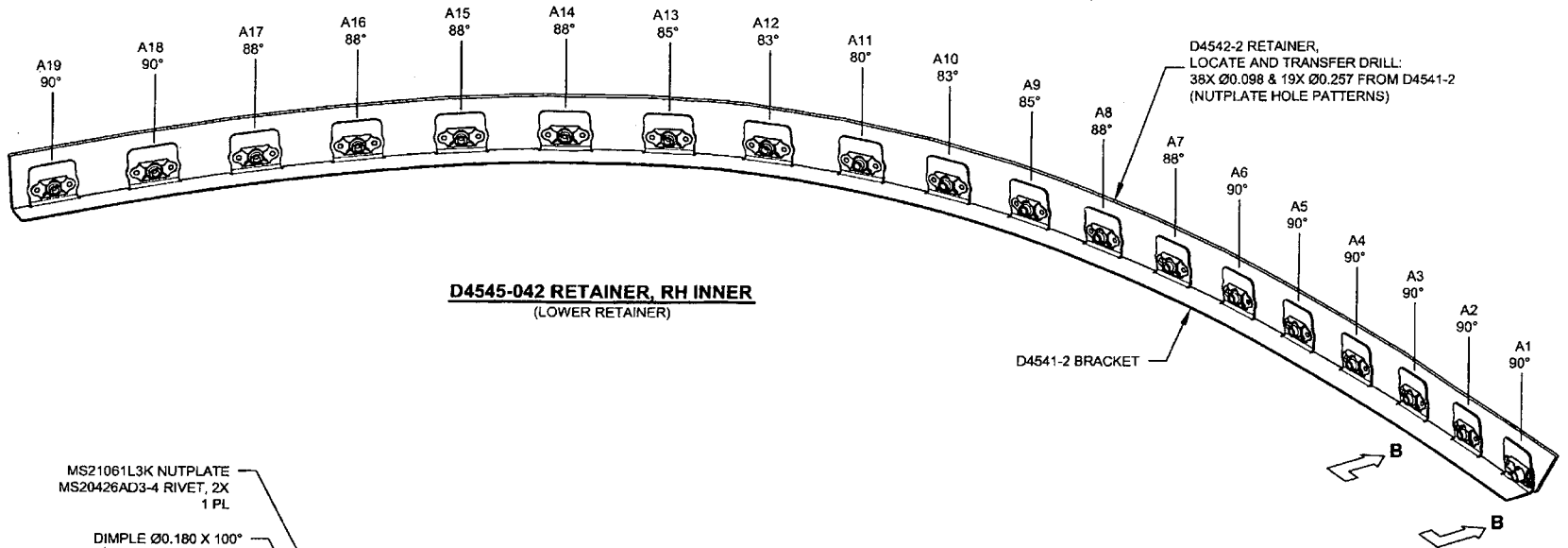
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

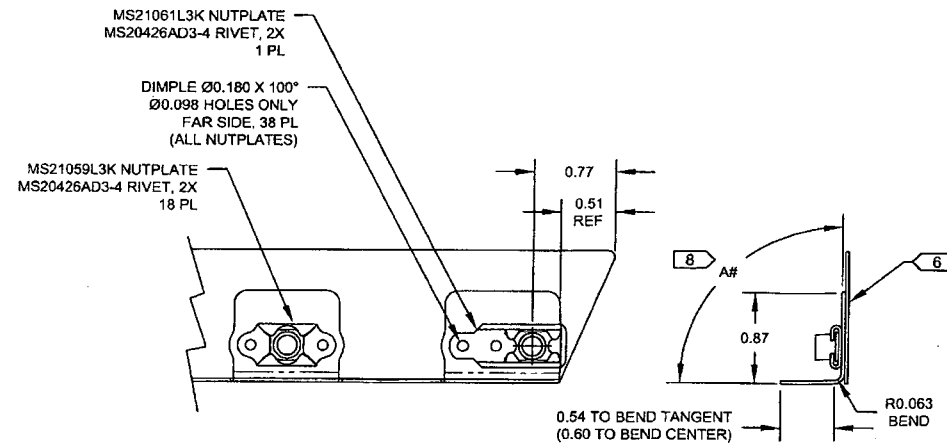
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

~~SECRET~~ 81941



**D4545-042 RETAINER, RH INNER**  
(LOWER RETAINER)



**VIEW B-B**  
NOT TO SCALE

RELEASED  
2012-02-16

DESIGN	DP	<b>DART AEROSPACE LTD</b>	
DRAWN	DP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.	SD	D4545	SHEET 3 OF 9
APPROVED		TITLE	SCALE
DE APPR.		RETAINER, INNER	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



81941

D4542-3 RETAINER,  
LOCATE AND TRANSFER DRILL:  
28X Ø0.098 & 14X Ø0.257 FROM D4541-3

**D4545-043 RETAINER, LH INNER**  
(SIDE RETAINER)

D4541-3 BRACKET

MS21059L3K NUTPLATE  
MS20426AD3-4 RIVET, 2X  
14 PL

DIMPLE Ø0.180 X 100°  
Ø0.098 HOLES ONLY  
FAR SIDE, 28 PL

**VIEW C-C**  
NOT TO SCALE

0.54 TO BEND TANGENT  
(0.60 TO BEND CENTER)

R0.063  
BEND

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.		D4545	SHEET 4 OF 9
APPROVED		TITLE	SCALE
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RELEASED  
2012-02-16  
AW

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

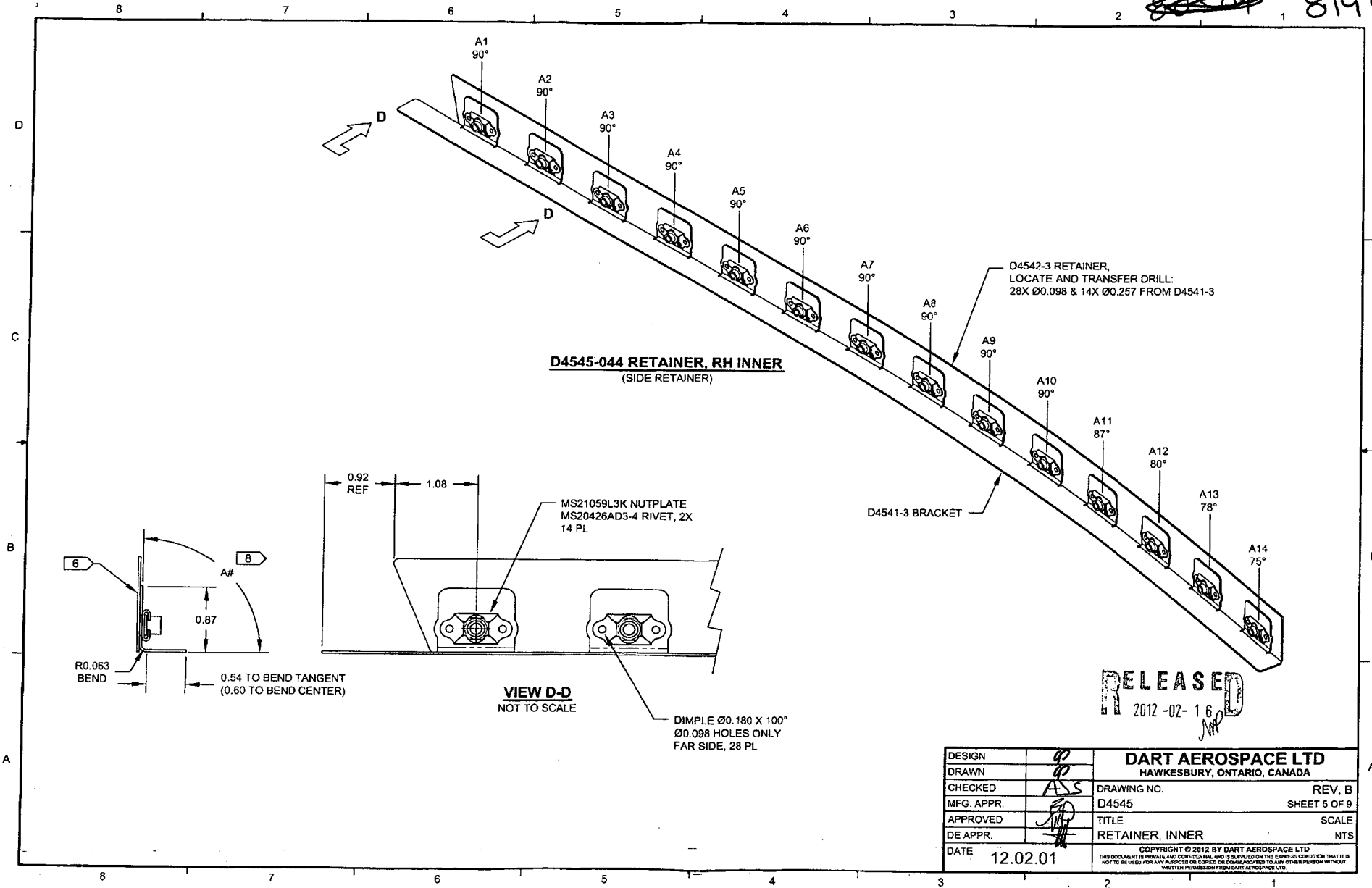
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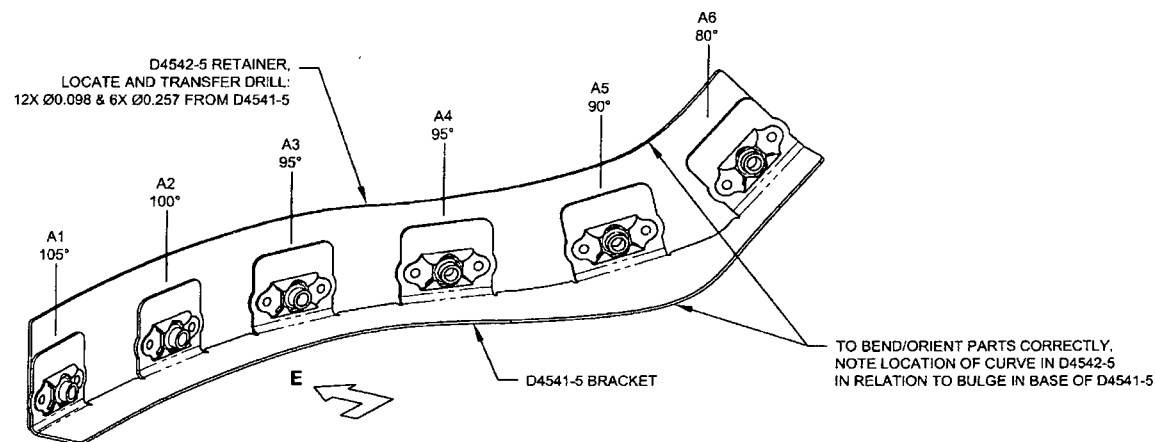
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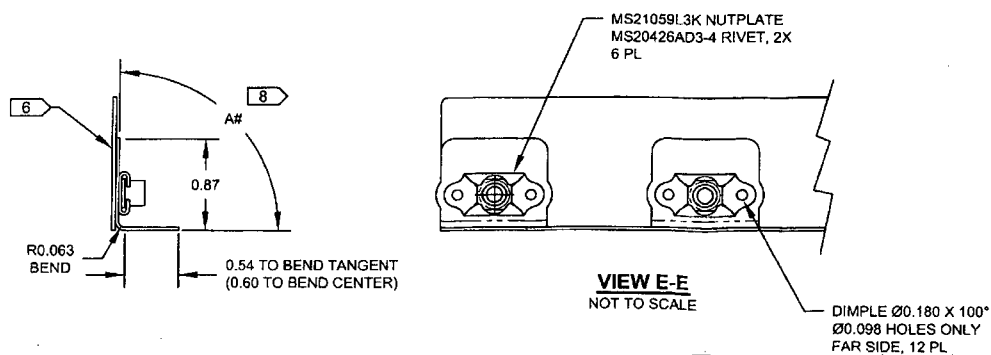
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**D4545-045 RETAINER, LH INNER**  
(TOP CORNER RETAINER)



RELEASED  
2012-02-16

DESIGN	Q	<b>DART AEROSPACE LTD</b>	
DRAWN	Q	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.	FO	D4545	SHEET 6 OF 9
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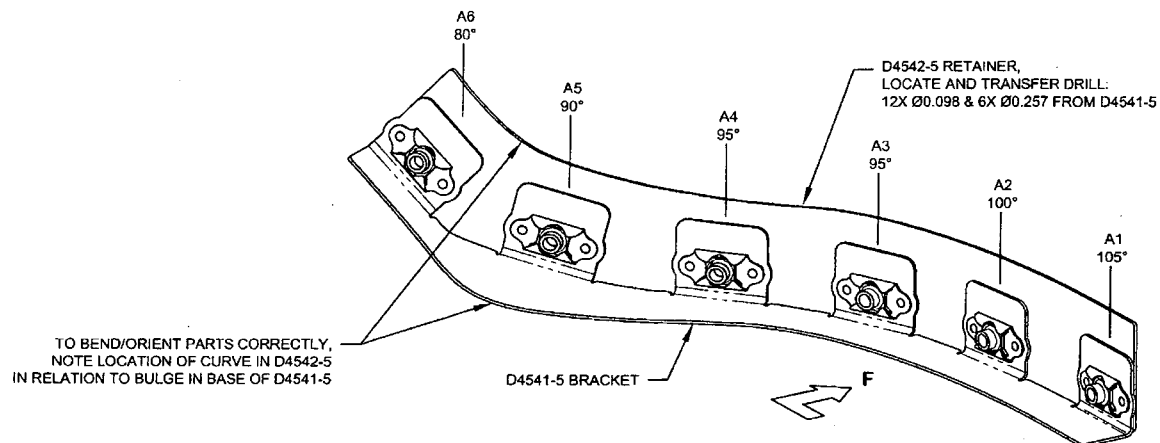
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

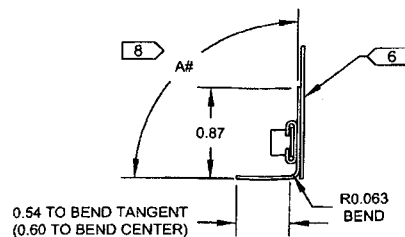
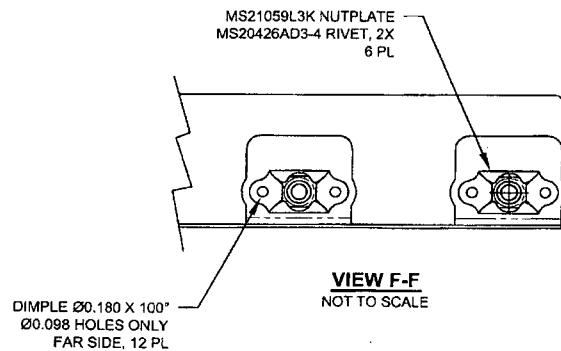
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

81941



**D4545-046 RETAINER, RH INNER**  
(TOP CORNER RETAINER)



RELEASED  
2012-02-16  
JMP

DESIGN	9	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.	MP	D4545	SHEET 7 OF 9
APPROVED		TITLE	SCALE
DE APPR.		RETAINER, INNER	NTS
DATE	12.02.01	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

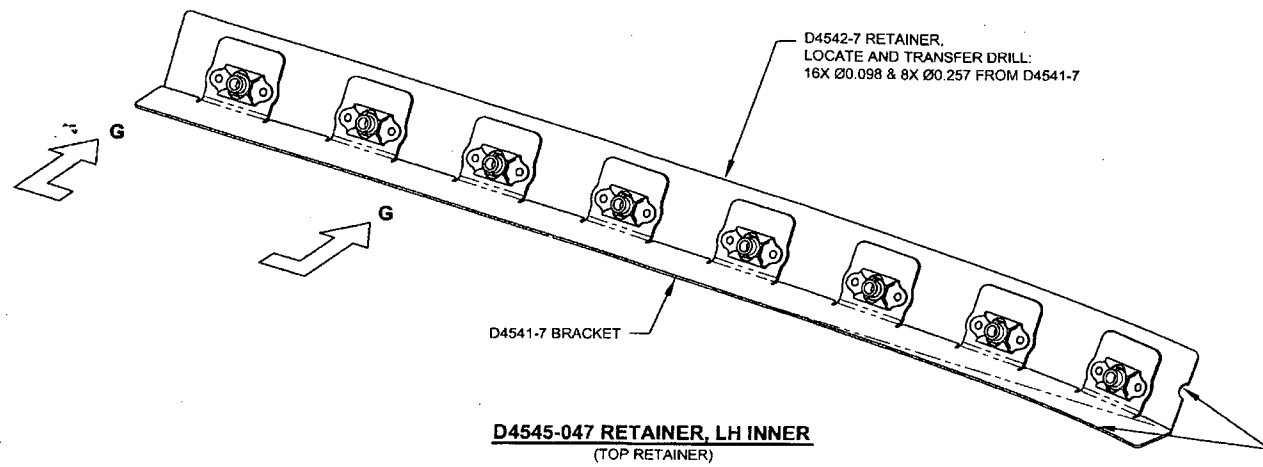
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



81941

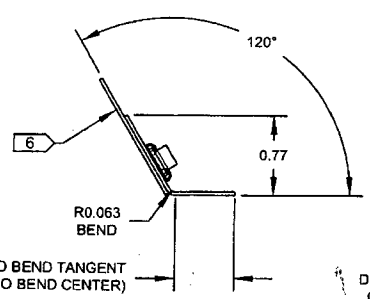


D4542-7 RETAINER.  
LOCATE AND TRANSFER DRILL:  
16X Ø0.098 & 8X Ø0.257 FROM D4541-7

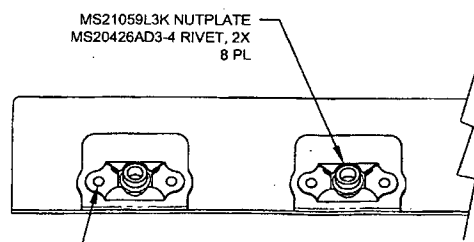
D4541-7 BRACKET

**D4545-047 RETAINER, LH INNER**  
(TOP RETAINER)

TO BEND/ORIENT PARTS CORRECTLY,  
NOTE LOCATION OF TOOLING MARK IN D4542-7  
IN RELATION TO CURVE IN BASE OF D4541-7



0.56 TO BEND TANGENT  
(0.60 TO BEND CENTER)



MS21059L3K NUTPLATE  
MS20426AD3-4 RIVET, 2X  
8 PL

DIMPLE Ø0.180 X 100°  
Ø0.098 HOLES ONLY  
FAR SIDE, 16 PL

**VIEW G-G**  
NOT TO SCALE

RELEASED  
2012-02-16

DESIGN	9	<b>DART AEROSPACE LTD</b>	
DRAWN	9	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.	130	D4545	SHEET 8 OF 9
APPROVED	MP	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

~~80507~~ 81941

TO BEND/ORIENT PARTS CORRECTLY,  
NOTE LOCATION OF TOOLING MARK IN D4542-7  
IN RELATION TO CURVE IN BASE OF D4541-7

D4542-7 RETAINER,  
LOCATE AND TRANSFER DRILL:  
16X Ø0.098 & 8X Ø0.257 FROM D4541-7

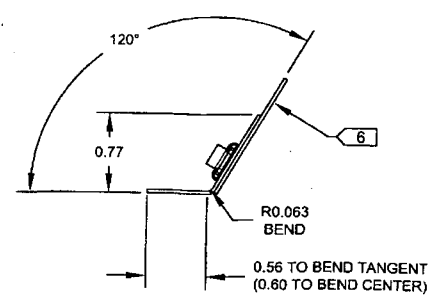
D4541-7 BRACKET

**D4545-048 RETAINER, RH INNER**  
(TOP RETAINER)

MS21059L3K NUTPLATE  
MS20426AD3-4 RIVET, 2X  
8 PL

DIMPLE Ø0.180 X 100°  
Ø0.098 HOLES ONLY  
FAR SIDE, 16 PL

**VIEW H-H**  
NOT TO SCALE



RELEASED  
2012-02-16

DESIGN	0	<b>DART AEROSPACE LTD</b>	
DRAWN	0	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.	ED	D4545	SHEET 9 OF 9
APPROVED	AP	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries